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(54) **PLANT FOR CONTINUOUS PROCESSING AND PACKING OF MEAT PRODUCTS AND METHOD FOR THE IMPLEMENTATION THEREOF**

(57) Plant for meat material treatment and packing in nonstop operation comprising:

- a station (10) for injecting brine to the meat material;
- a station (20) for macerating including a rotatory drum (22) for massaging injected meat material and resting tanks (24) for massaged meat material which travel step-by-step along a closed path (26) around the rotatory drum (22), prepared for receiving meat material from the rotatory drum (22) and keeping it resting, and

- a station (30) for packing the massaged and rested meat material.

The stations (10, 20, 30) are coupled for nonstop operation, linked by an accumulating and loading unit (40) for injected meat material towards the drum (22) and a unit (60) transferring and feeding the massaged and rested meat material to said packing station (30), the operating steps of said stations (10, 20, 30) and units (40, 60) being coordinated from a computer central control.

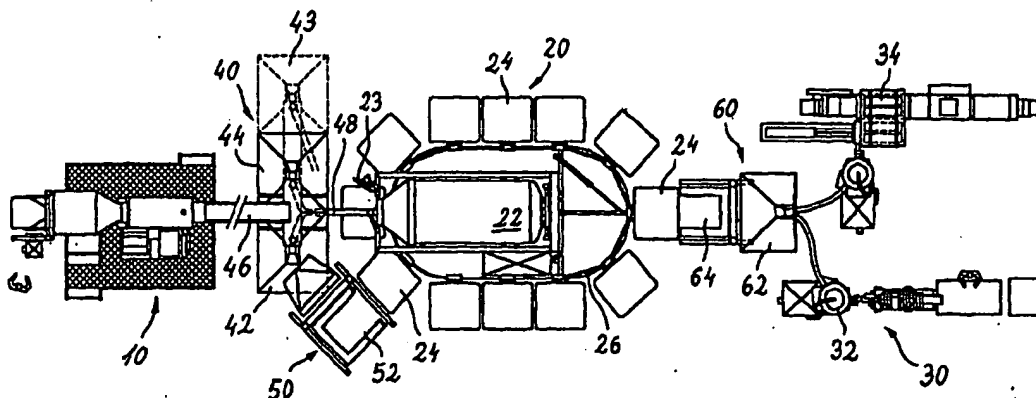


fig. 1

Description

Field of the art

[0001] This invention relates to a plant for nonstop treating and packing meat materials, namely for treating and packing medium sized meat material designed to products such as cooked ham, roast beef, corned beef, whole fowls or certain fowl or pork sausages. Said treatment includes a step of injecting brine to said meat material, one or more steps of massage matched with one or more steps of rest and one step of packing, for example, by stuffing or thermoforming. This invention also relates to a process for nonstop treating and packing meat material.

Background of the invention

[0002] In the state of the art, apparatuses for injecting brine to meat materials are well-known, units for carrying out one or more massage-rest consecutive treatments having a predetermined duration and packing machines which include stuffing machines, stapling machines, dosing machines, thermoforming machines and the like, by means of which plants for treating and packing meat material are installed. Document US-A-4791 705, granted to this applicant, discloses a machine for treating and macerating meat, that is to say, for submitting the meat material to massage-rest consecutive treatments, provided with automatic loading and unloading and provided with a computer centralized control, marketed by Metalquimia, S.A. with the brand Thermocomputer. Said machine includes a rotatory drum which has at an axial end a loading-unloading mouth provided with a door with adjusting and closing devices. The drum is supported and guided by a frame, which is hinged at one end with respect to a part of the fixed structure, so that the frame, and with it the drum, can adopt an inclined position towards one or the other side or keep an horizontal position. A moving structure surrounds the drum, said structure being provided with a step-by-step travel on which a series of containers are mounted for pieces of meat material. In front of said drum loading-unloading mouth there is a loading device capable to turn a load contained in a container down a hopper arranged to load the drum. For unloading the drum there exists means for lifting the rear part thereof so that its contents is unloaded through the loading-unloading mouth within an empty container submitted to weigh control.

[0003] Most of these machines are capable of a non-stop operation. However, the meat material produced by a machine must be accumulated within containers which are hand moved or by means of mechanical trucks up to the following machine for feeding it, for which a great number of operators and a large space for containers travels are required. The different machines have different production capabilities and in ad-

dition they must be thoroughly cleaned each given number of cycles or working hours, or when starting the treatment of a new type of meat material the conditions of which are incompatible with those of the preceding one, therefore frequently it happens that an excess of meat material is accumulated from a machine because of a temporary incapability of the following one for admitting it, or that a machine must stay stopped because of a temporary incapability of production of the preceding machine. This produces loss of productivity in the plant and in addition it obliges to a complex and expensive programming of the times of production of the different units and of accumulation and travel of containers of semifinished meat material between them.

[0004] Therefore, an object of this invention is to contribute with a plant for treating and packing meat material in which the different units are coupled to each other for a nonstop operation, linked by units for accumulating, loading, unloading and/or feeding semifinished meat material, and in which every unit is controlled and coordinated by central control electronic means.

[0005] Another object of the invention is to contribute with a plant for nonstop treating and packing meat material in which the operating cycles of the different units are controlled and coordinated so that times for cleaning each unit are available while at least one of the remaining units is operating.

Short explanation of the invention

[0006] These objects are achieved according to this invention by contributing with a plant for nonstop treating and packing meat material comprising:

- a station for injecting brine to the meat material;
- a station for macerating including at least a rotatory drum for massaging injected meat material and a plurality of resting tanks for massaged meat material which can travel step-by-step along a closed path around said rotatory drum, which is at least one, prepared for receiving said meat material from the rotatory drum and keeping it resting up to the moment of emptying it; and
- a station for packing the treated meat material; said stations being coupled to each other for nonstop operation, linked by:
 - a unit for accumulating and loading the rotatory drum, located between the outlet of said injecting station and the inlet of said macerating station; and
 - a unit for transferring and feeding, located between a given point of said path and said packing station, the steps of operation of the different stations and units being coordinated from at least one computer control centre so that at any moment of an operation cycle of the plant, at least one of the stations is operating, a time for cleaning each station, unit or part thereof being provided during said cycle, keeping

the plant nonstop operation.

[0007] The plant also comprises a reloading unit including means for newly transferring massaged-rested meat material from said resting tanks to said massaging drum so that said meat material can be submitted to repeated massing-resting subcycles before it is fed to the packing station.

[0008] Optionally, the plant in addition includes an automatic cleaning unit for the resting tanks located at a point of said closed path.

[0009] With said arrangement, the plant operation cycle starts at the injecting station, which preferably comprises a conventional nonstop injecting machine, such as a multineedle injecting machine with spraying effect Movistick of Metalquimia S.A., Girona, Spain. The injected meat material is transferred by carrying means to the accumulating and loading unit, located adjacent to a loading-unloading mouth of said rotatory drum. Said accumulating and loading unit has two or more hoppers and means for distributing the meat material so that it alternately fills one hopper when the other is being emptied and its contents is loaded in the rotary drum to be submitted to a massage treatment, which typically comprises a knock and friction action of the pieces of meat material with each other and against the drum walls matched with a pulmonary action or alternate cycles of atmospheric pressure and vacuum at a given temperature. Advantageously, the capability of each of the hoppers of the accumulating and loading unit corresponds to the loading and treatment capability of the rotatory drum.

[0010] Once a massaging operation of a load within the rotatory drum is completed, the massaged pieces of meat material are transferred from the drum to one or more of said resting tanks where said pieces rest during a suitable period of time, during which time said tank or tanks, together with the remaining ones, are moved step-by-step along said path. Immediately after unloading the drum contents in respective tanks, the drum is newly filled with a new load. The transfer of meat material from the loading hoppers to the drum is carried out through high vacuum sucking. The arrangement and operation of the macerating station is similar to the one disclosed in said document US-A-4791705.

[0011] When all the tanks are filled with pieces of meat material submitted to a first massaging action, the injecting station stops and, after a given time of rest, if no further macerating actions are required, a sequential transfer of the load is started from the resting tanks to a feeding hopper of one or more packing machines at a packing station. The most usual packing machines are a nonstop stuffing machine, as for example the Twinvac of Metalquimia S.A. matched with an automatic stapling machine or a dosing machine matched with a thermofforming machine. The means for transferring the contents of the resting tanks to the different hoppers are lifting-tilting machines, such as for example the hydrau-

lic lifting-tilting machine Alpha of Metalquimia S.A.

[0012] However, usually it is required that the pieces of meat material are submitted to several repeated proceedings of massaging-resting before their packing, for which the loads having rested in the tanks must be newly transferred to the rotatory drum for a further massaging action and thereafter they must be newly loaded in the resting tanks for a new period of rest, and this subcycle can be repeated if required, several times within the plant general treatment cycle. For this purpose, at a point of the path adjacent to the accumulating and loading unit, there is said reloading unit located, which takes a full tank, lifts it and turns its contents down one of the hoppers of the accumulating and loading unit, which in that moment is empty, and in the event that a load of the drum occupies more than one resting tank, said operation is repeated until the whole load distributed in several tanks has been transferred to said hopper, from which said load is newly transferred to the drum, where it is submitted to a new massage, after which the load is newly emptied in respective resting tanks, which remained empty during the massaging operation, while the following load in turn has been or is being transferred to the loading hopper and so on until completing one or more massaging-resting subcycles for every load. When the last massaging-resting subcycle is completed, with every resting tank filled and the drum empty, the packing step is started in an analogous way as above disclosed.

[0013] When the injecting step ends, the injecting machine stops and it can be thoroughly cleaned together with the parts of the accumulating and loading unit which are idle while the macerating station is operating. When the last massaging action of the last load of an operation cycle is completed it can be proceeded to a thorough cleaning of the rotatory drum which has available an automatic cleaning device, and of those parts of the accumulating and loading unit which were not previously cleaned and thereafter a new cycle can be started with the injection of new loads, while the transferring and feeding unit goes on feeding the packing station, which is in full production.

[0014] As the resting tanks are remaining empty, after their contents has been turned down the feeding hopper of the packing station, said tanks can be thoroughly cleaned in said automatic cleaning unit located in the path the tanks follow downstream under said transferring and feeding unit, remaining available to be filled with the massaged meat material loads, from the rotatory drum, of the new cycle. This is very important because it makes that the plant of this invention is capable to carry out consecutive cycles treating different types of meat material, eventually incompatible with each other, or even to process loads of said different types of meat material within a same cycle, proceeding to due cleaning between cycles or loads.

[0015] When the meat material packing step corresponding to the first cycle is completed, the packing ma-

chines stop and it can be proceeded to thoroughly clean them as well as their corresponding feeding hopper and elements associated to them while the injecting station, the accumulating and loading unit and the macerating station are newly operating within the following cycle.

Short description of the drawings

[0016] This invention is illustrated thereafter by means of a detailed description of preferred examples of embodiment with reference to the appended drawings, in which:

Fig. 1 is a schematic plan view of a plant for nonstop treating and packing meat material according to a first example of embodiment of this invention.

Fig. 2 is a flow chart which illustrates the flows of meat material in a plant of this invention;

Fig. 3 to 5 are plan enlarged part views of a plant according to a second example of embodiment of this invention; and

Fig. 6 and 7 are schematic diagrams illustrating a process for nonstop treating and packing meat material which can be implemented with the plant of Fig. 1 or the plant of Fig. 3 to 5.

Detailed description of examples of preferred embodiments

[0017] Referring first to Fig. 1, the plant of this invention comprises an injecting station 10 of brine to the meat material; a macerating station 20 including at least a rotatory drum 22 for massaging the injected meat material and a plurality of resting tanks 24 for the massaged meat material which can travel step-by-step along a closed path 26 around said rotatory drum 22, which is at least one, prepared for receiving meat material from said drum 22 and keep it resting until the moment of its emptying; and a packing station 30 for the treated meat material. Stations 10, 20, 30 are coupled to each other for a nonstop operation, linked by an accumulating and loading unit 40 to the rotatory drum 22, located between the outlet of said injecting station 10 and the inlet of said macerating station 20; and a transferring and feeding station 60, located between a given point of said path 26 of the macerating station 20 and said packing station 30.

[0018] The operating steps of the different stations 10, 20, 30 and units 40, 60 are coordinated from at least a computer control centre (not shown), so that at any moment of an operation cycle of the plant at least one of the stations 10, 20, 30, unit 40, 60 or part thereof is provided during said cycle. The complete process for nonstop treating and packing meat material will be described with more details below with reference to Fig. 6 and 7.

[0019] Advantageously, the plant comprises in addi-

tion a reloading unit 50 integrated in said macerating station including means for newly transferring massaged-rested meat material from said resting tanks 24 to said rotatory drum 22, so that said meat material can be submitted to repeated subcycles of massaging-resting before it is fed to the packing station 30.

[0020] Said closed path 26 of the resting tanks 24 includes at least a first stopping area under a loading/unloading mouth 23 of the massaging rotatory drum 22, a second stopping area close to the transferring and feeding unit 60 and a third stopping area close to the said reloading unit 50. The resting tanks 24 are linked to dragging means in closed circuit along said path 26, being detachable from said dragging means at least in some of said stopping areas.

[0021] In order to be able of nonstop operating, said accumulating and loading unit 40 comprises 2 In the event that a single massaging operation is required, followed by a single resting period of time for the meat material before it is fed to the transferring and feeding station 60, when all the tanks 24 are full, the injecting station 10 and the accumulating and loading unit 40 stop and it can be proceeded to their cleaning while the resting period of time of the meat material is completed in the resting tanks 24 and its feeding to the packing station 30 starts through the transferring and feeding unit 60.

[0022] If required, as it usually happens, that the meat material is submitted to repeated massaging-resting subcycles before it is fed to the packing station 30, said reloading unit 50 is used, as it was stated before, the means of which for transferring massaged-rested meat material from the resting tanks 24 to said massaging drum 22 comprise a lifting-tilting apparatus 52 capable to sequentially take each of the filled resting tanks 24, from said third stopping area of the path 26, for lifting them, turn their contents down said first hopper 42 of the accumulating and loading unit 40 and bringing them back, empty, to said third stopping area of the path 26. For this, said first hopper 42 of the accumulating and loading unit 40 must be empty, therefore the reloading operations start when all the resting tanks 24 are filled and the injecting station 10 stopped. This way, while reloading operations of the further massaging-resting subcycles are carried out, it can be proceeded to cleaning the injecting station 10 and the second hopper 44 and carrying-distributing means 46 of the accumulating and loading unit 40.

[0023] When said further massaging-resting subcycles are completed it is proceeded to feed the treated meat material to the packing station 30 through the transferring and feeding unit 60, which includes means for transferring massaged-rested meat material from said resting tanks 24 to at least a feeding hopper 62 from one or more packing machines 32, 3.4 of the packing station 30, the means of which typically comprise a lifting-tilting apparatus 64 capable of taking one of said resting tanks 24 filled from said second stopping area of the path 26, lifting it, turning it to transfer its contents

down the feeding hopper 62 and bringing it back, empty, to said second stopping area of the path 26. The resting tanks 24, as they are remaining empty can be cleaned and ready for a new cycle.

[0024] The new cycle can start by injecting meat material at the injecting station 10 and filling the hoppers 42, 44 of the accumulating and loading unit 40, while the feeding tasks are carried out at the packing station 30 by means of the transferring and feeding unit 60, provided that the rotatory drum 22 is empty, and if required cleaned, when the contents of the first or the second hopper 42, 44, within the new cycle, must be loaded in said drum.

[0025] Last, the packing station 30 and the transferring and feeding unit 60 can be cleaned when the meat material packing of first cycle is completed and while the meat material of the new cycle is being injected and submitted to a first massaging-resting subcycle of the new cycle.

[0026] In Fig. 2 a plan flow chart is shown as above described, where the flows of the meat material are shown by means of arrows. In said diagram, an optional third hopper 43 is shown with a dot line, in the accumulating and loading unit 40 which serves to be able to simultaneously carry out the loading tasks of the rotary drum 22 with reloading tasks thereof with rested meat material from the resting tanks 24.

[0027] In Fig. 3 to 5 a plant according to another example of embodiment of this invention is shown, which is fully similar to the one described with relation to Fig. 1 but with a higher capability of production, therefore identical numerals have been used for similar elements.

[0028] The plant of Fig. 3 to 5 has a larger capability rotatory drum and a greater number of resting tanks 24 arranged in a longer path 26. Subsequently, the injecting station 10 and packing station 30 also have a larger capability of production and the hoppers 42, 44, 62 of the accumulating and loading unit 40 and the transferring and feeding units 60 are larger. However, for easy handling purpose, the capability of the tanks 24 of the plant of Fig. 3 to 5 is similar to that of the tanks 24 of the plant of Fig. 1. Therefore, the contents of each massaged meat material load by rotatory drum 22 of Fig. 3 to 5 is going to fill three resting tanks 24 instead of the two tanks which the rotatory drum load of Fig. 1 would fill. This is the reason why the plant of Fig. 3 to 5 has a greater number of resting tanks 24, concretely eighteen, than the plant of Fig. 1, where there are only twelve. It is to be pointed out, however, that both plants include a respective number of resting tanks 24 equally corresponding to six loads of the rotatory drum 22. Obviously, the number of loads capable to be temporarily kept resting in the resting tanks 24 is variable depending on the number thereof available and related length of the path 26, and will depend on the characteristics of the facilities and the operation cycles it is wished to be established, according to different types of meat material to be treated or different end products to be obtained.

[0029] The plant of Fig. 3 to 5 in addition includes an automatic cleaning unit 70 of the resting tanks 24 located at a point of the closed path 24 downstream said transferring and feeding unit 60. Said cleaning unit 70 includes means for taking one of said empty resting tanks 24 from a fourth stopping area of the path 26, to transfer it to an automatic cleaning device 72 and bringing it back once it is clean to said fourth stopping area of the path 26, ready for a new cycle. The rotatory drum 22 has also available a fully automated cleaning device, without requiring an operator to intervene. Other elements, such as hoppers 42, 44, 62, can also be provided with automatic cleaning devices provided that they meet the local standards of health.

[0030] In Fig. 6 and 7, schematic diagrams illustrate the steps of the process for nonstop treating and packing meat material of this invention. In this description, when the term "load" is used, it refers to an amount of meat material corresponding to the rotatory drum 22 loading and treating capability, each of said loads, depending on the size of the drum 22 with relation to the resting tanks 24 can occupy one, two, three or more of said resting tanks 24. It is important to point out to this respect, that in order the figures and following explanation are clearer and simpler, the process is shown in an example implemented in a plant similar to those illustrated in Fig. 1 to 5 but simplified, with a rotatory drum 22 the load of which is capable to fill the single tank 24 and with only four loads of the drum 22, for each production cycle of the plant, therefore only four tanks 24 have been illustrated at the maceration station 20.

[0031] The process is characterized in that a series of operations and treatment are carried out, in a chained and automated way under a centralized control, using stations and operation units which are adjacent, linked, forming a production line of coordinated operation which can operate in a nonstop way, so that at any moment of a working cycle at least one of the stations is operating, and at least two different meat material loads are being simultaneously submitted to one of said operations or treatments, a time for cleaning each station, unit or part thereof being provided during said cycle.

[0032] Fig. 6 illustrates the process of this invention according to a basic cycle including a single massage-rest subcycle, which is composed of following steps:

- a) injecting pieces of meat material with brine at an injecting station 10, with which for example, first cycle is started;
- b) carrying pieces of injected meat material from preceding step a) for accumulating them in a first hopper 42 of an accumulating and loading unit 40 constituting a first load A;
- c) carrying pieces of injected meat material from step a) for accumulating them in a second hopper 44 of said accumulating and loading unit 40, constituting a second load B while at same time said first load A is transferred from said first hopper 42 to a

massaging rotatory drum 22 of a macerating station 20 and the first massaging action of the first load A starts.

d) carrying the pieces of injected meat material from the step a) for accumulating them in the first hopper 42 constituting a third load C while said first massaging action of the first load A is completed and said load is transferred from the rotatory drum 22 to one of the resting tanks 24 to submit the first load A to a first resting period of time and it is proceeded to transfer said second load B from said second hopper 42 to the rotatory drum 22 and a first massaging action of the second load B starts;

e) carrying pieces of injected meat material from the step a) for accumulating them in the second hopper 44 constituting a fourth load D while said first massaging action of the second load B is completed and said load is transferred from the rotatory drum 22 to another of the resting tanks 24 to submit the second load B to a first resting period of time and it is proceeded to transfer said third load C from the first hopper 42 to the rotatory drum 22 and the first massaging action of the third load C starts,

f) stopping the injecting station 10 and proceeding, if required, to its cleaning (illustrated by means of divergent arrows) while said first massaging action of the third load C is completed and is transferred from the rotatory drum 22 to another of the resting tanks 24 for submitting the third load C to a first resting period of time and it is proceeded to transfer said fourth load D from the second hopper 44 to the rotatory drum 22 and a first massaging action of the fourth load D starts;

g) transferring the fourth load D, once its first massaging action is completed, from the rotatory drum 22 to the last (for example in this case 4) of the resting tanks 24 for submitting the fourth load D to a first resting period of time, with which there are no longer empty tanks 24, at which moment it can be proceeded, if required, to cleaning the accumulating and loading unit (40) and the rotatory drum (22) (the cleaning of which would be essential for preparing said elements for a second cycle with a kind of meat material incompatible with those of the first cycle), while with transferring means 64 of a transferring and feeding unit 60 the first massaged-rested load A corresponding to the resting tank 24 is transferred to a hopper 62 of said transferring and feeding unit 60, although said transfer could be carried out directly from the resting tank.

h) feeding the first load A from said hopper 62 to the packing station 30 while it is sequentially going on with the transfer of the remaining massaged-rested loads B, C, D, from the respective resting tanks 24 to said hopper 62, and it is sequentially proceeded to clean the tanks 24, as they are being emptied, for example, in an automatic cleaning unit 70 situated at a point of said closed path 26, at which mo-

ment a second cycle can be started with analogous steps to those of steps a) and following ones for constituting and treating loads P,Q,R,S of meat material within said second cycle; and

i) cleaning the transferring and feeding unit 60 and the packing station 30 once the packing action of loads A, B, C, D of the first cycle is completed while it is proceeded with the injecting and macerating actions of said loads P, Q, R, S of the second cycle and so on.

[0033] In Fig. 7, steps p), q), r), s) are illustrated which are being intercalated between steps f) and g) of Fig. 6 in a very generalized case, in which more than one massaging-resting subcycle for each load before proceeding to the packing. Thus, between said steps f) and g) of Fig. 6, following steps are included:

p) transferring the first load A, which has been submitted to a first massaging action and to a first resting period of time, from the respective resting tank 24 to said first hopper 42 of the accumulating and loading unit 40 by means of reloading unit 50, while it is eventually going on cleaning the injecting station 10 and cleaning the second hopper 44, and related elements, of the accumulating and loading unit 40;

q) transferring the first load A from the first hopper 42 to the rotatory drum 22 and starting a second massaging action of the first load A and meanwhile transferring the second load B, which has been submitted to a first massaging action and to a first resting period of time, from the respective resting tank 24 to the first hopper 42;

r) transferring the first load A, once the second massaging action is completed, from the rotatory drum 22 to the respective resting tank 24 (the same which contained the load A during the first resting period of time and which remained empty during the second massaging action) for submitting it to a second resting period of time and thereafter loading the second load B from the first hopper 42 to the rotatory drum 22 and starting a second massaging action of the second load B; and so on until every load A, B, C, D have been submitted to a second massaging-resting subcycle.

[0034] In the event that further massaging-resting subcycles are required, the following step is carried out:

s1) carrying out further subcycles of steps analogous to the steps p) to r) (without the cleaning operations) for submitting the loads A, B, C, D to further massaging actions and to further resting actions, after which it is proceeded with the step g) of Fig. 6.

In the event that two massaging-resting subcycles are sufficient, it is passed to the step:

s2) going on with the step g) while the cleaning of the first hopper 42 and related elements of the accumulating and loading unit 40 and the rotatory drum 22 of the macerating station 20 is carried out.

[0035] As stated above, although the figures illustrate each meat material load occupying only one resting tank 24, usually each load occupies two (Fig. 1) or three (Fig. 3 to 5) resting tanks 24 the contents of which as a whole can be treated in a single rotatory drum 22 load.

[0036] A man of the art of this sector can introduce multiple variations to the examples of embodiment illustrated in the figures and above described, which are quoted only for illustration purpose therefore they ought not be purported to limit the scope of the invention, which is defined in the appended claims. In particular, although Fig. 1 to 4 show a linear arrangement plant, the different units and/or stations can be linked in any other arrangement, for example at 90°, zigzag, et.

Claims

1. Plant for nonstop treating and packing meat material which comprises:

- a station (10) for injecting brine to the meat material;
 - a station (20) for macerating including at least a rotatory drum (22) for massaging injected meat material and a plurality of resting tanks (24) for massaged meat material associated to carrying means for travelling step-by-step along a closed path (26) around said rotatory drum (22), which is at least one, prepared for receiving meat material from said rotatory drum (22) and keeping it resting up to the moment of emptying it; and
 - a station (30) for packing the treated meat material;
- said stations being coupled to each other for nonstop operation, linked by:
- a unit (40) for accumulating and loading the rotatory drum (22), located between the outlet of said injecting station (10) and the inlet of said macerating station (20); and
 - a unit (60) for transferring and feeding treated meat material at said packing station (30), located between a given point of said path (26) of said macerating station (20) and said packing station (30),

the steps of operation of the different stations (10, 20, 30) and units (40, 60) being coordinated from at least one computer control centre so that at any moment of an operation cycle of the plant, at least one of the stations is operating, a time for cleaning each

station, unit or part thereof being provided during said cycle, keeping the plant nonstop operation.

2. Plant, according to claim 1, **characterized in that** in addition it comprises a reloading unit (50) integrated in said macerating station (20) including means for newly transferring massaged-rested meat material from said resting tanks (24) to said rotatory drum (22), so that said meat material can be submitted to repeated subcycles of massaging-resting before it is fed to the packing station (30).

3. Plant according to claim 1 or 2, **characterized in that** said accumulating and loading unit (40) comprises at least a first hopper (42) and a second hopper (44), carrying-distributing means (46) for alternatively filling said first and second hoppers (42, 44) with injected meat material from the injecting station (10) and transferring means (48) for selectively transferring the load from the first and second hoppers (42, 44) to the rotatory drum (22) of the macerating station.

4. Plant, according to claim 3, **characterized in that** said transferring means (48) comprise a system of suction ducts driven by a vacuum generated within said rotatory drum (22) or a lifted assembly for directly unloading in the drum access mouth (22).

5. Plant, according to claim 1, 2 or 3, **characterized in that** said transferring and feeding unit (60) includes means for transferring the massaged-rested meat material from said resting tanks (24) to at least one feeding hopper (62) of one or more packing machines (32, 34) of the packing station (30).

6. Plant, according to any of the claims 2 to 5, **characterized in that** said closed path (26) of the resting tanks (24) which are travelling step-by-step include at least a first stopping area under a loading/unloading mouth (23) of the massaging rotary drum (22), a second stopping area close to the transferring and feeding unit (60) and a third stopping area close to said reloading unit (50).

7. Plant, according to claim 6, when it depends from claim 5, **characterized in that** said means for transferring massaged-rested meat material from said resting tanks (24) to said feeding hopper (62) comprise a lifting-tilting apparatus (64) capable to take one of the filled resting tanks (24) from said second stopping area of the path (26), for lifting it, turning its contents down for transferring it to said feeding hopper (62) and bringing it back, empty, to said second stopping area of the path (26).

8. Plant according to claim 6, **characterized in that** said means for transferring the massaged-rested

- meat material from said resting tanks (24) to said massaging drum (22) comprise a lifting-tilting apparatus (52) capable to take one of the filled resting tanks (24), from said third stopping area of the path (26), lifting it, turn it for transferring its contents down said first hopper (42) of the accumulating and loading unit (40) and bringing it back, empty, to said third stopping area of the path (26).
9. Plant according to any of the preceding claims, **characterized in that** in addition it includes and automatic cleaning unit (70) for the resting tanks (24) located at a point of said closed path (26).
10. Plant, according to claim 9, **characterized in that** said cleaning unit (70) includes means for taking one of said empty resting tanks (24) from a fourth stopping area of the path (26), to transfer it to an automatic cleaning device (72) and bringing it back once it is clean to said fourth stopping area of the path (26).
11. Plant according to any of the preceding claims, **characterized in that** said resting tanks (24) are linked to dragging means in closed circuit along said path (26), the tanks (24) being detachable from said dragging means at least in some of said stopping areas.
12. Process for nonstop treating and packing meat material which comprises the operations of:
- injecting brine to pieces of meat material;
 - macerating said injected meat material submitting it to one or more alternate massaging actions with one or more resting periods of time; and
 - packing the treated meat material,
- characterized in that** said operations are carried out, in a chained and automated way under a centralized control, using stations and operation units which are adjacent, linked, forming a production line of coordinated operation which can operate in a nonstop way, so that at any moment of a working cycle at least one of the stations (10, 20, 30) is operating, and at least two different meat material loads are being simultaneously submitted to one of said operations or treatments, a time for cleaning each station, unit or part thereof being provided during said cycle, keeping the nonstop operation of the plant.
13. Process according to claim 12, **characterized in that** it carries out by means of chained cycles each of which comprises the steps of:
- injecting brine to said meat material at an injecting station (10)
 - carrying, with carrying-distributing means (46), pieces of injected meat material from the injecting station (10) and alternately accumulating them in at least a first and second hoppers (42, 44) of an accumulating and loading unit (40), so that the contents accumulated in each of said first and second hoppers (42, 44) corresponds to a load of a rotary massaging drum (22) of a macerating station (20) and carrying out said accumulation at each of said hoppers while alternately the content of another of said hoppers (42, 44) is being transferred to said rotatory drum (22), each of said loads being submitted to a first massaging action within the drum (22) and later on unloaded in one or more resting tanks (24) of a plurality of resting tanks (24) which can travel step-by-step along a closed path (26) around said rotatory drum (22), before proceeding to newly loading the drum (22).
 - sequentially submitting the content of each load to a first resting period of time within corresponding one or more resting tanks (24).
 - sequentially transferring, once every resting tank (24) have been filled, from the drum (22), with transferring means (64) of a transferring and feeding unit (60), the massaged-rested loads of the corresponding one or more resting tanks (24) to a hopper (62) of said transferring and feeding unit (60), and
 - feeding from said hopper (62) one or more packing machines (32, 34) of a packing station (30) and packing said meat material.
14. Process, according to claim 13, **characterized in that** said chained cycles in addition integrate following steps:
- stopping the injecting station (10) when an amount of meat material from a first cycle has been injected sufficient for filling every resting tank (22) arranged at the macerating station (20) and proceeding, if required, to clean said injecting station (10) while the nonstop operation of the plant is kept with operations of the first cycle;
 - stopping the carrying-distributing means (46) when it has been proceeded to transfer the last injected meat material load of the first cycle from the first and second hoppers (42, 44) to the rotatory drum (22) and to proceed, if required, to clean said carrying-distributing means (46) and said first hopper (42) and second hopper (44) while the nonstop operation of the plant is kept with operations of the first cycle;
 - stopping the rotatory drum (22) when it has

been proceeded to transfer the last load of massaged meat material of the first cycle from the rotatory drum (22) to the last one or more empty resting tanks (24) and proceeding, if required, to cleaning said rotatory drum (22), while the nonstop operation of the plant goes on with operations of the first cycle and to start injecting meat material from a second cycle at the injecting station (10), if wished, and to carry and accumulate by means of the accumulating and loading unit (40);

- sequentially cleaning, if required, the tanks (24) as they are emptied, by hand or with an automatic cleaning unit (70) situated at a point of said closed path (26) while the nonstop operation of the plant goes on with operations of said first cycle and said second cycle.
- cleaning, if required" the transferring and feeding unit (60) and the packing station (30) once the meat material packing action of the first cycle is completed while the nonstop operation of the plant goes on with operations of the second cycle, and so on with further chained cycles.

15. Process, according to claim 13 or 14, **characterized in that** after submitting the meat material loads of a first cycle to said first resting period and before proceeding to the packing operations said loads of the first cycle are submitted to one or more further macerating operations, for which following steps are carried out:

- sequentially transferring the meat material loads submitted to a first massaging action and to a first resting period from corresponding one or more resting tanks (24) to said first hopper (42) of the accumulating and loading unit (40) by means of a reloading unit (50), and from the first hopper (42) to the rotatory drum (22), submit them to a second massaging action and bring them newly back to corresponding one or more resting tanks (24) to submit them to a second resting period; and if required
- repeating the further reloading operations at the rotatory drum (22), massaging, bringing back to the resting tanks (24) and rest as many times as macerating operations with intercalation of resting steps are wished.

16. Process, according to claim 12, 13, 14 or 15 **characterized in that** in consecutive cycles, or in consecutive loads, different types of meat material are treated, the operating conditions and operations being suitable automatic for each operation at the requirements of each kind of meat material, including cleaning the required elements when the conditions of the meat material of a new cycle or load are in-

compatible with those of the preceding load.

17. Process, according to claim 16, **characterized in that** the meat material kinds to be treated in consecutive cycles or loads are sequentially ordered so that whenever it is possible, the conditions of the meat material for each new cycle or load are compatible with those of the preceding load.

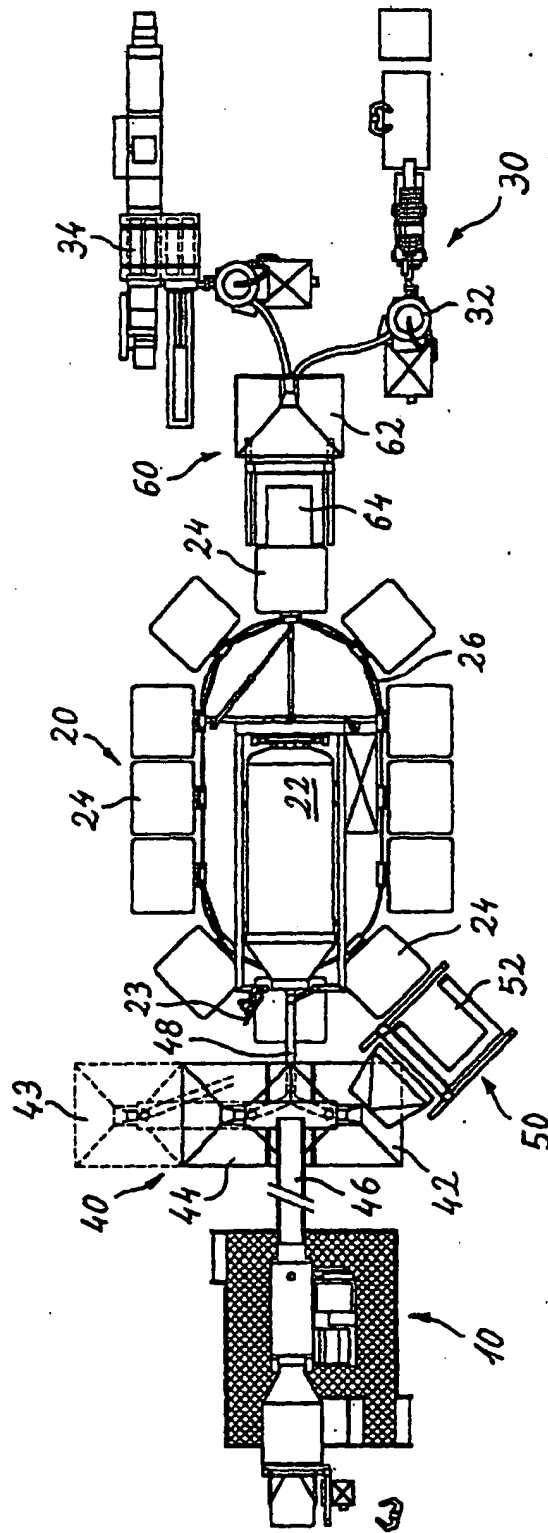


fig. 1

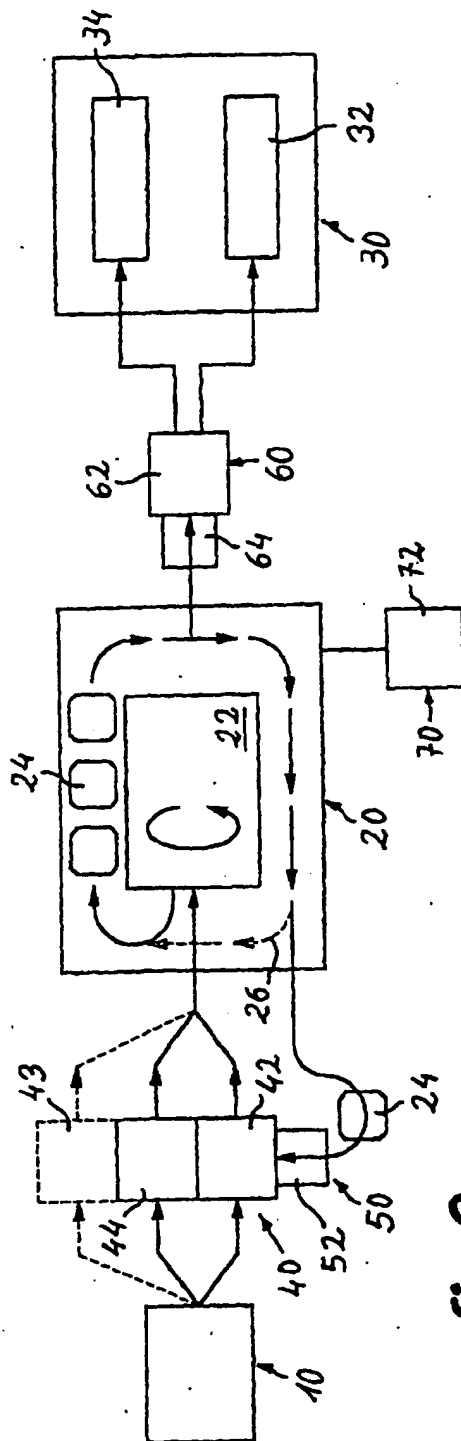


fig.2

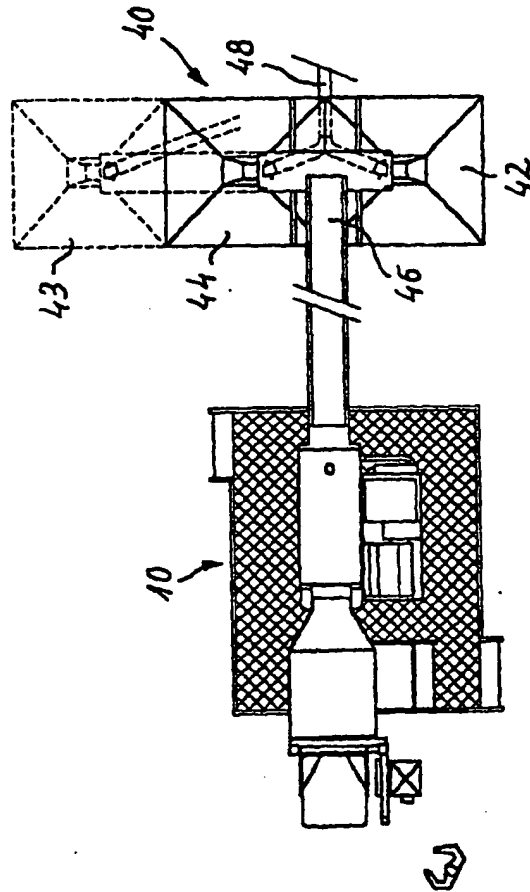
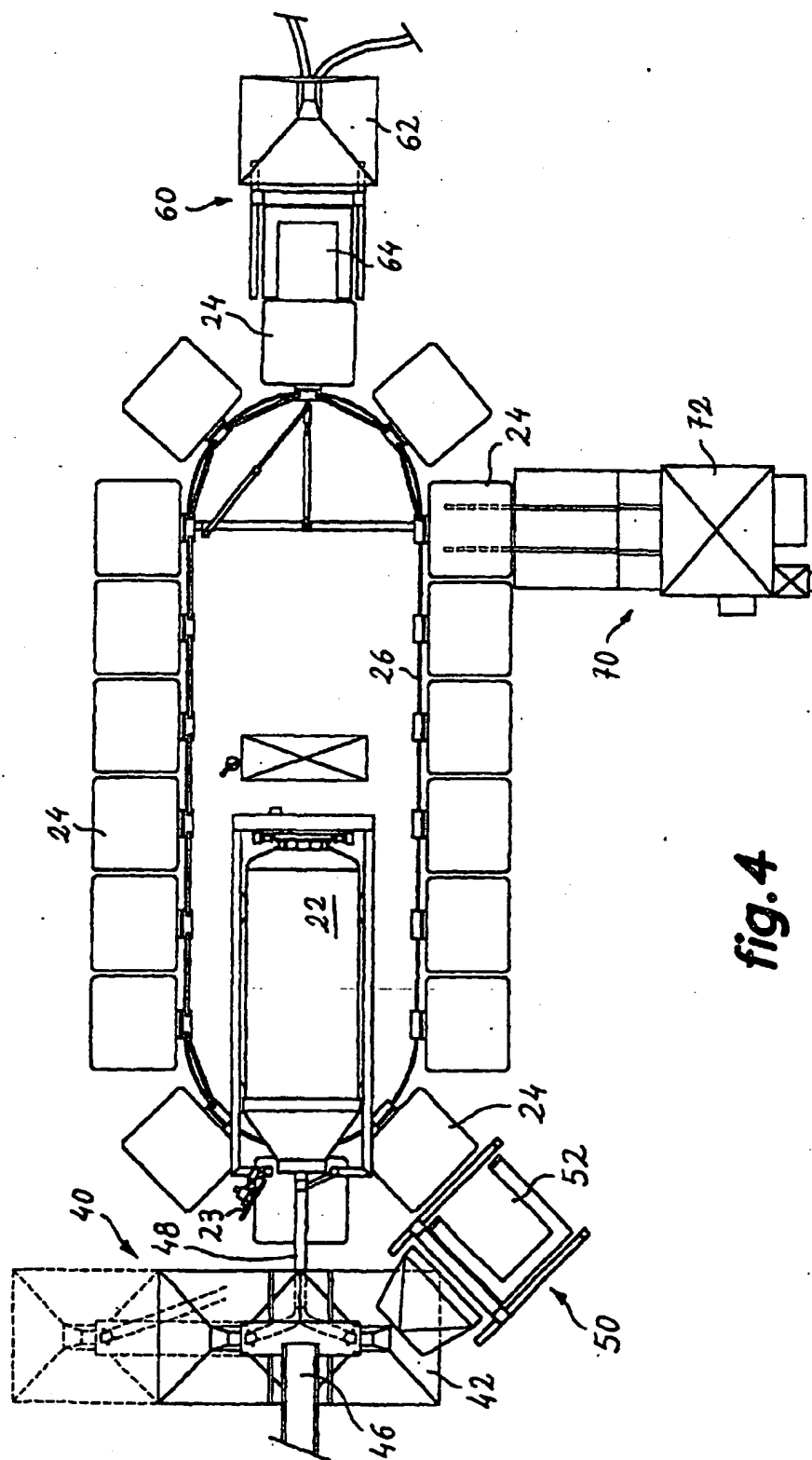


fig.3



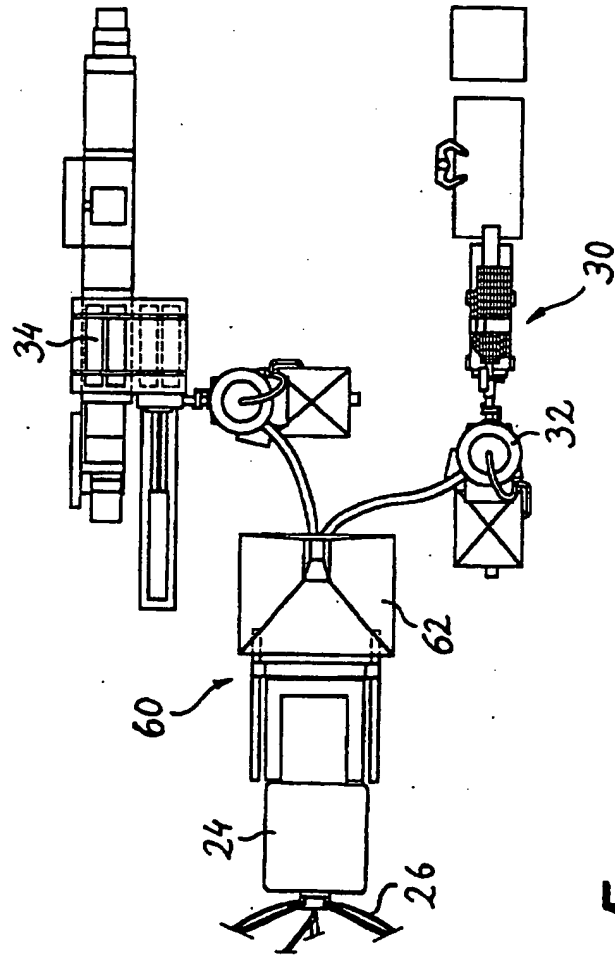


fig.5

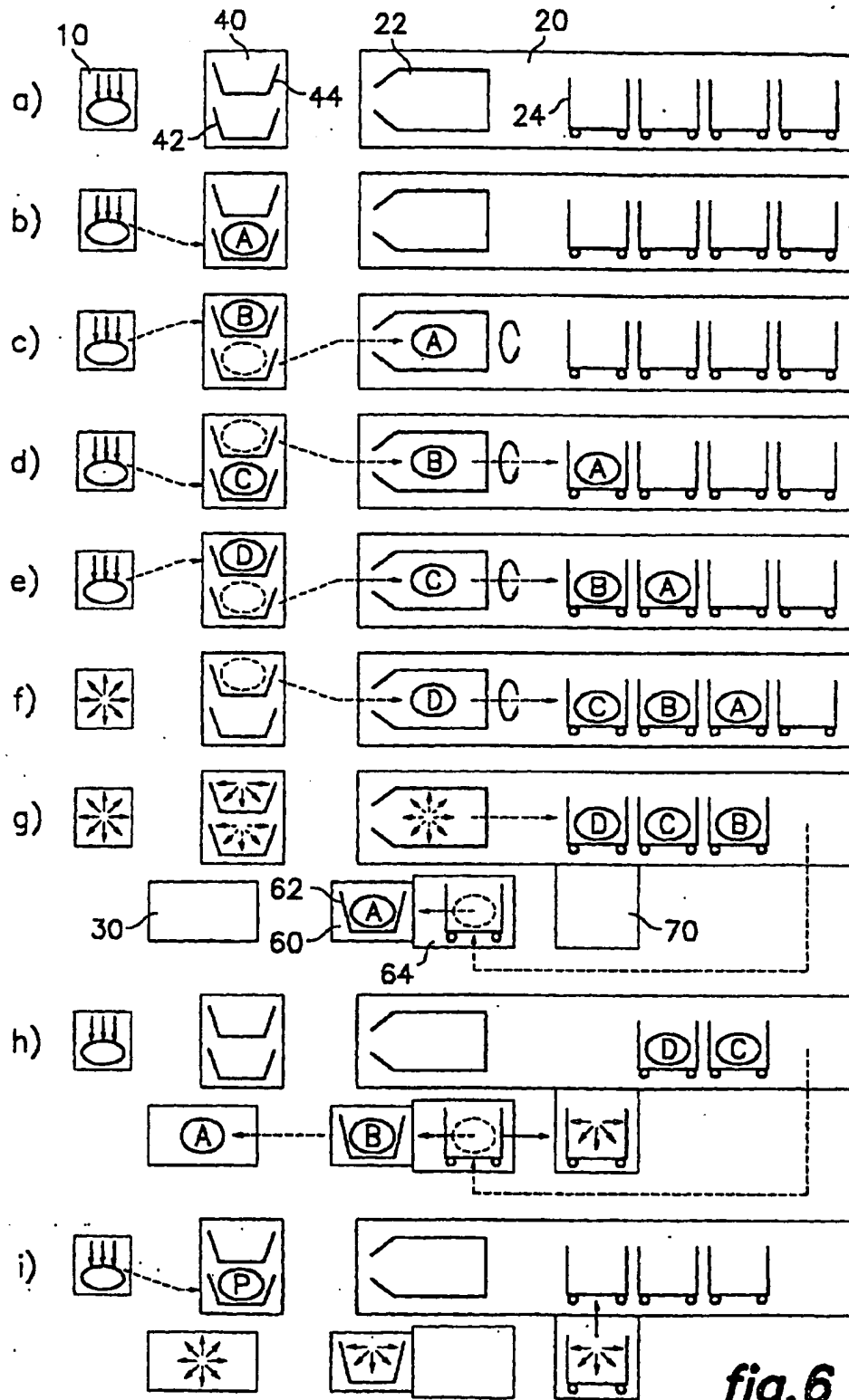


fig. 6

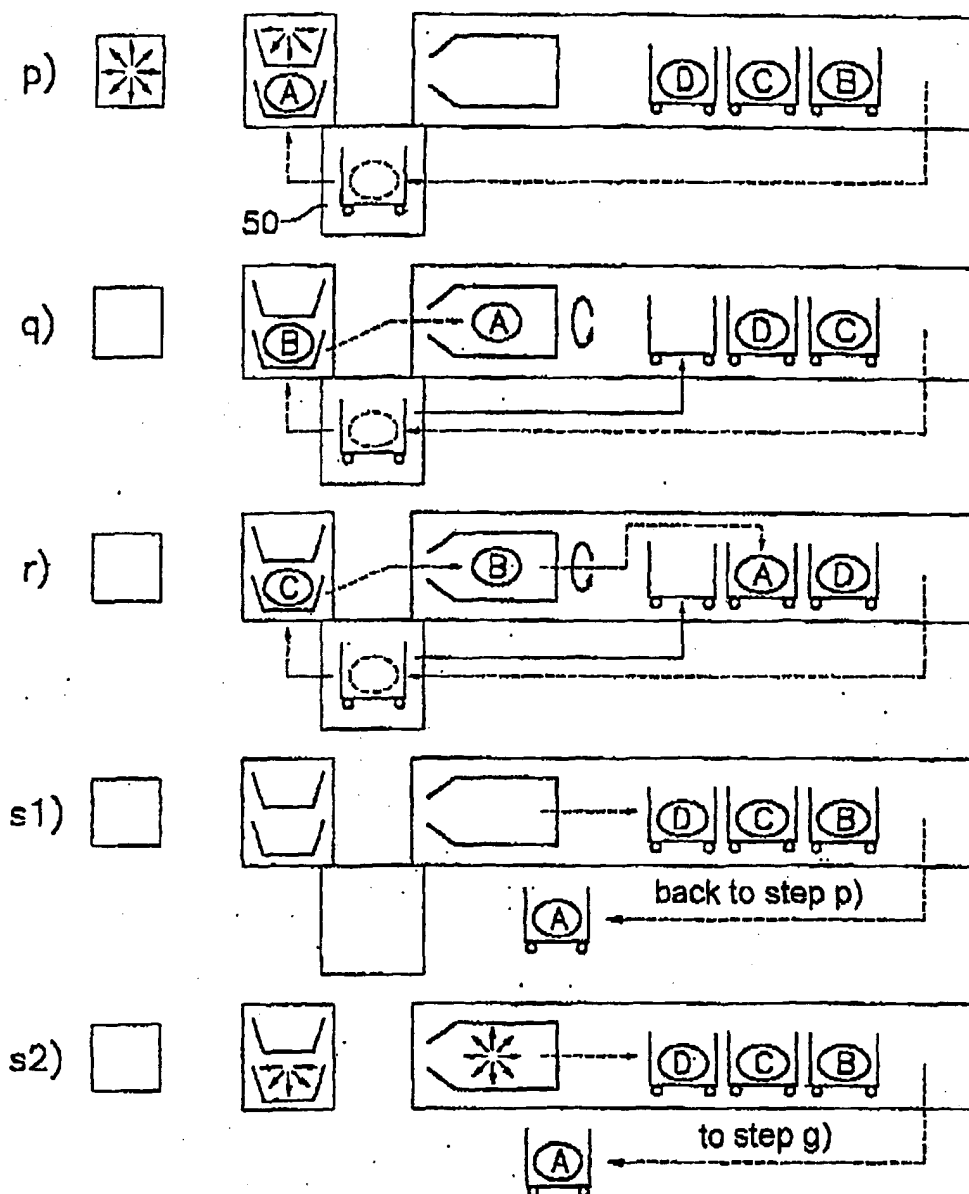


fig. 7

INTERNATIONAL SEARCH REPORT

Intern. Application No.
PCT/ES 00/00061

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 A22C18/00 A22C17/00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 A22C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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A	EP 0 455 611 A (ALIMATIC S R L) 6 November 1991 (1991-11-06) figures 1-4 -----	7,8

☐ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

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INTERNATIONAL SEARCH REPORT
 Information on patent family members

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